Dart Aerospace Ltd.

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D2571/D2572/D2573/D2574
Job Number	: 23374		
Estimate Number	: 10804		
P.O. Number	: N/A	Part Number	: Z_CUSTOM
This Item	: 3/24/2003 S.O. No. : N/A	Drawing Number	: RTN465
Prod Item	: NC	Project Number	: N/A
Fixt Item	: N/A Type : N/A	Drawing Revision	: N/A
Previous Run	: 00015	Material	: N/A
Written By		Due Date	: 3/31/2006 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :	
1.0	QC5	INSPECT WORK TO CURRENT STEP	06.03.24
	Comment: INSPECT RTN 465		
2.0	POWDER COATING	POWDER COATING	
	Comment: POWDER COATING STRIP POWDER COAT OFF SADDLES: 2 X D2571 B23801 / B24125 2 X D2572 B23801/ B24125 2 X D2573 B24126/ B23509 2 X D2574 B24126/B23802		FC 06 05 29 (8)
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
	Comment: SMALL & MEDIUM FAB RESOURCE 1 CHAMFER SADDLES BY HAND TO NEW REV. E ON ABOVE SADDLES	2 x B23801 (D2571/D2572) 2 x B24126 (D2573/D2574) 2 x B23802 (D2573/D2574)	Es 06/05/30
4.0	QC5	INSPECT WORK TO CURRENT STEP	06.05.30 8
	Comment: INSPECT WORK TO CURRENT STEP		
5.0	POWDER COATING	POWDER COATING	(PD)
	Comment: POWDER COATING TOUCH UP SADDLES WITH ALODINE POWDER COAT WHITE AS PER QSI 005 (REF. 4.3.5.1)		DC 06/06/20 x E DC 06/06/22 x2 Last Sheet

Form: rprocess

[redacted]

[redacted]

[redacted]

Date: Friday, 3/24/2006 8:29:09 AM
User: Linda Lacelle

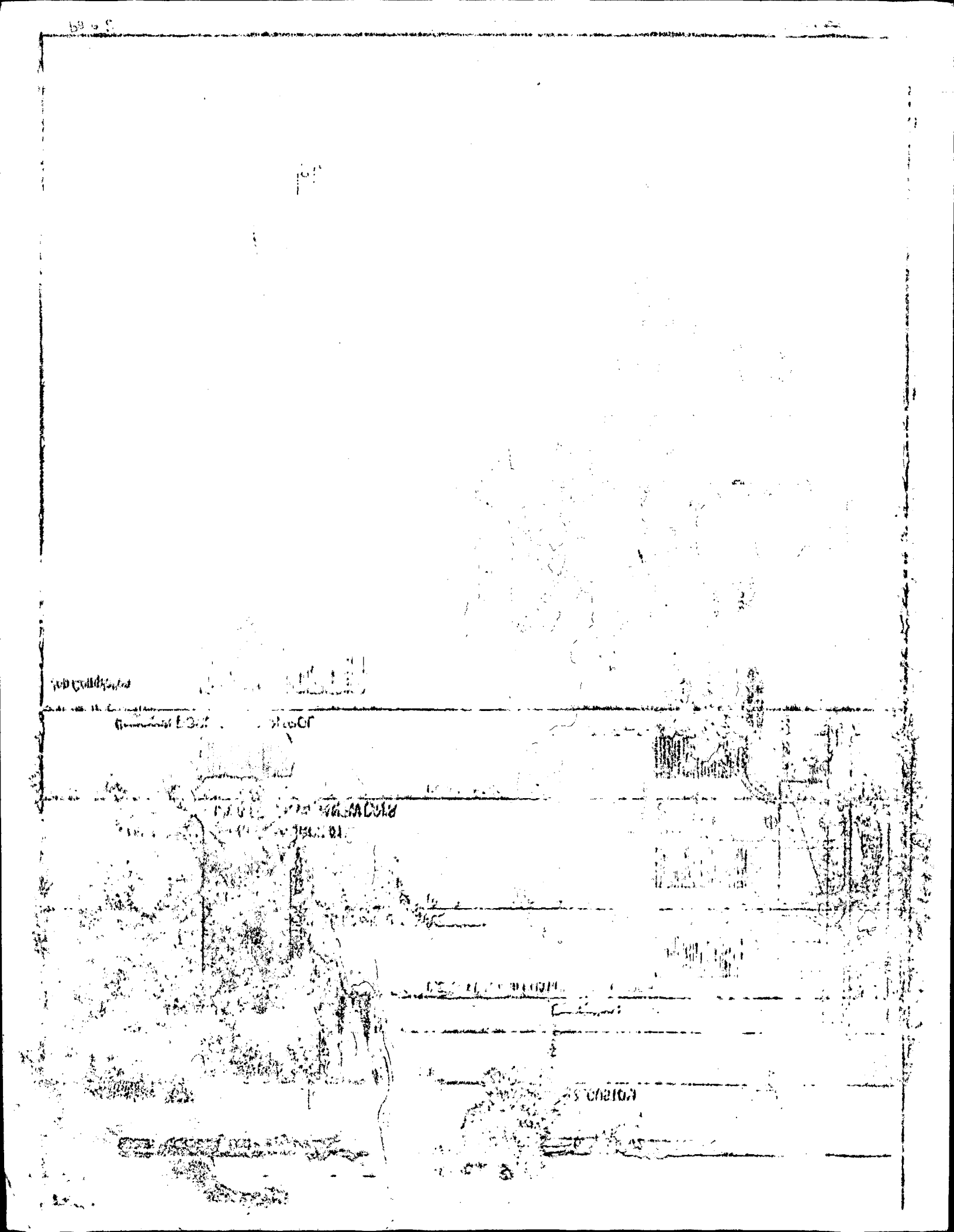
Process Sheet

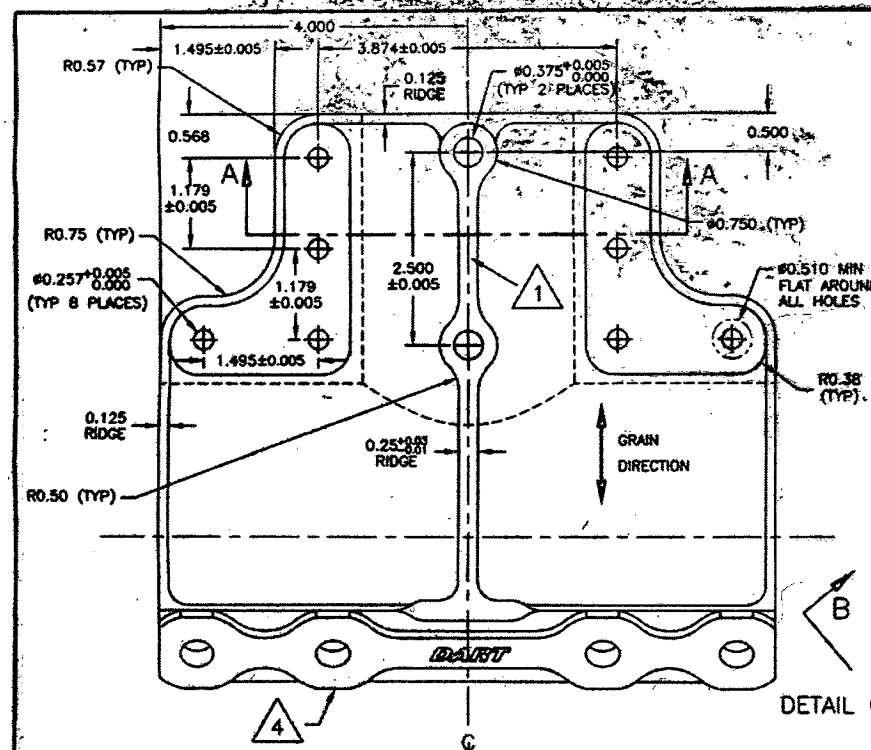
Customer: C-DARC Dart Aerospace Ltd.
Drawing Name: D2571/D2572/D2573/D2574
Job Number: 20374
Part Number: Z_CUSTOM
Job Number

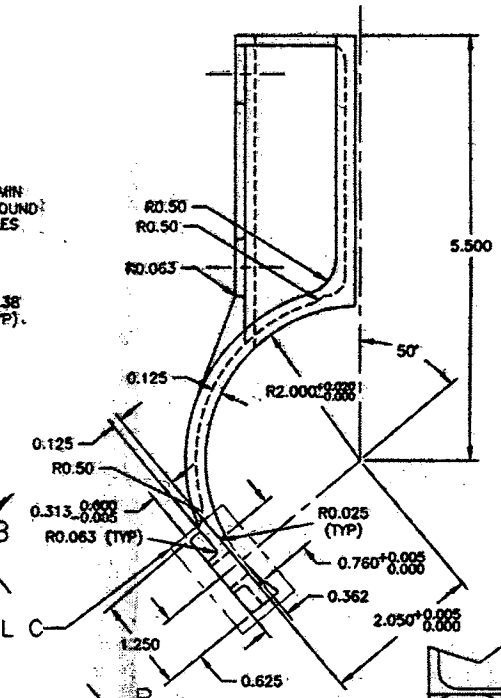
Seq.	Machine Or Operation	Description :
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	
7.0	PACKAGING	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 IDENTIFY & STOCK WITH NEW B/N'S	
8.0	DC	DOCUMENT CONTROL
	Comment: DOCUMENT CONTROL	

Job Completion

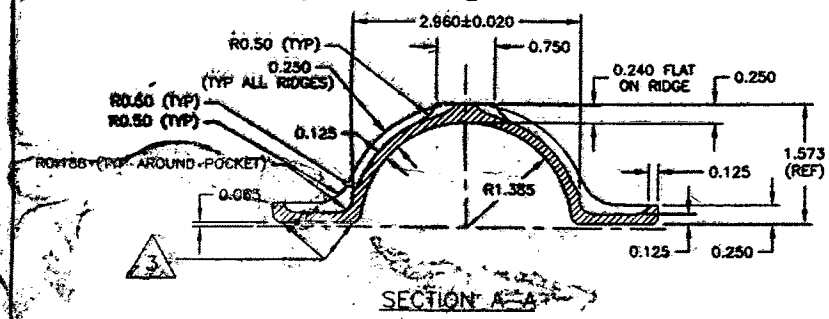
Form: rprocess



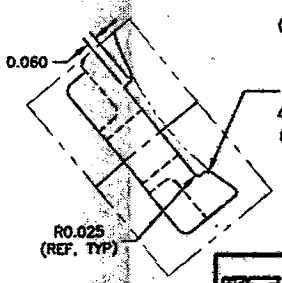




DETAIL C



SECTION A–A



DETAIL C
SCALE 4:3

RELEASED
05.12.6

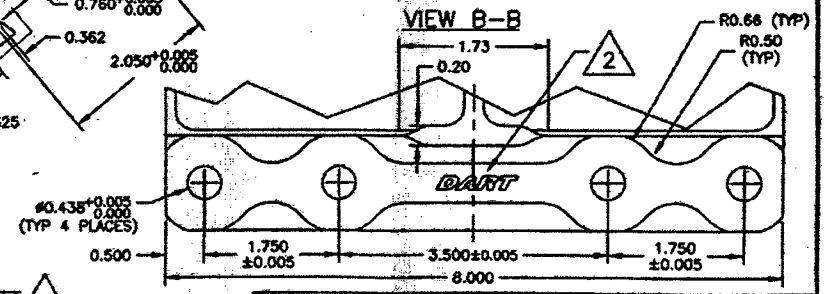
NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

1. ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
2. ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
3. CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
4. CHAMFER 0.063" x 45° ALL AROUND
5. CHAMFER 0.033" x 45° (SEE DETAIL C)

E

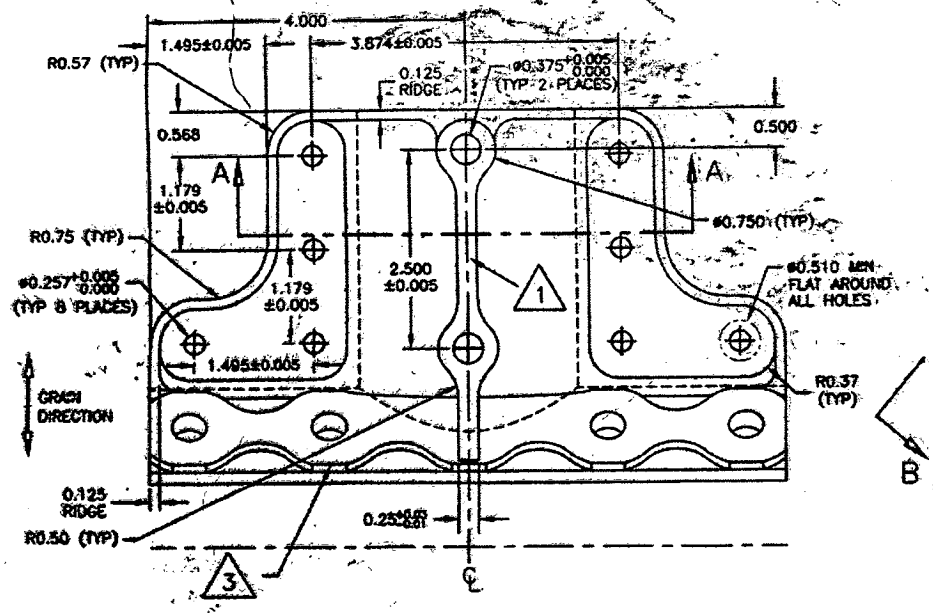
VIEW B–B

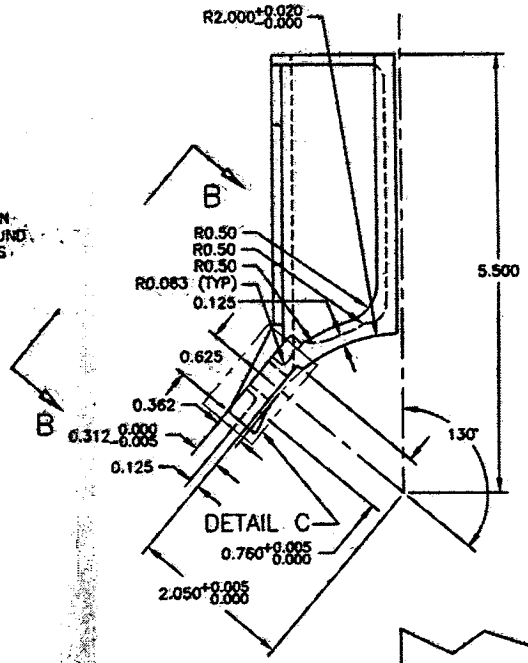


E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN: DS	DRAWN BY: PH	DART AEROSPACE LTD.
CHECKED	APPROVED	DRAWING NO. D2571 — REV. E — SHEET 1 OF 1
DATE: 05.07.13		TITLE: OUTER FWD SADDLE — SCALE 2:3

RELEASED
05.12.06





NOTES

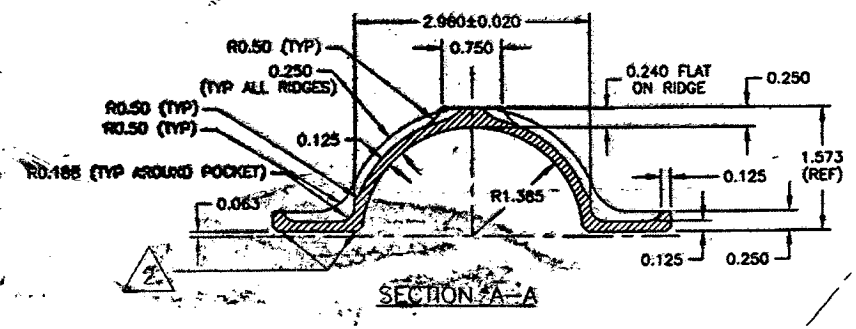
MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-003)

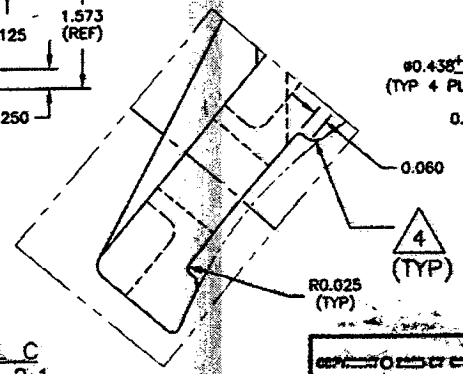
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3

BREAK ALL SHARP EDGES 0.010 TO 0.020

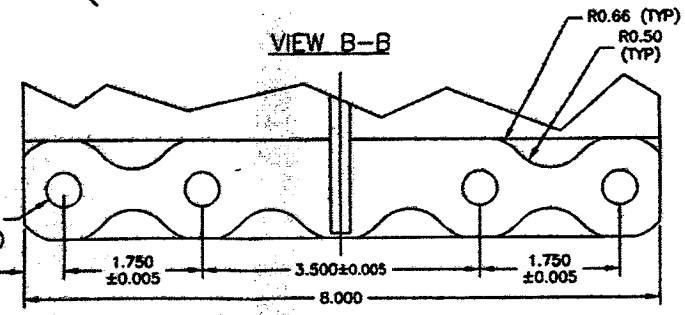
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

1. ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
2. CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
3. CHAMFER 0.063 x 45° ALL AROUND
4. CHAMFER 0.033 x 45° (SEE DETAIL C) E



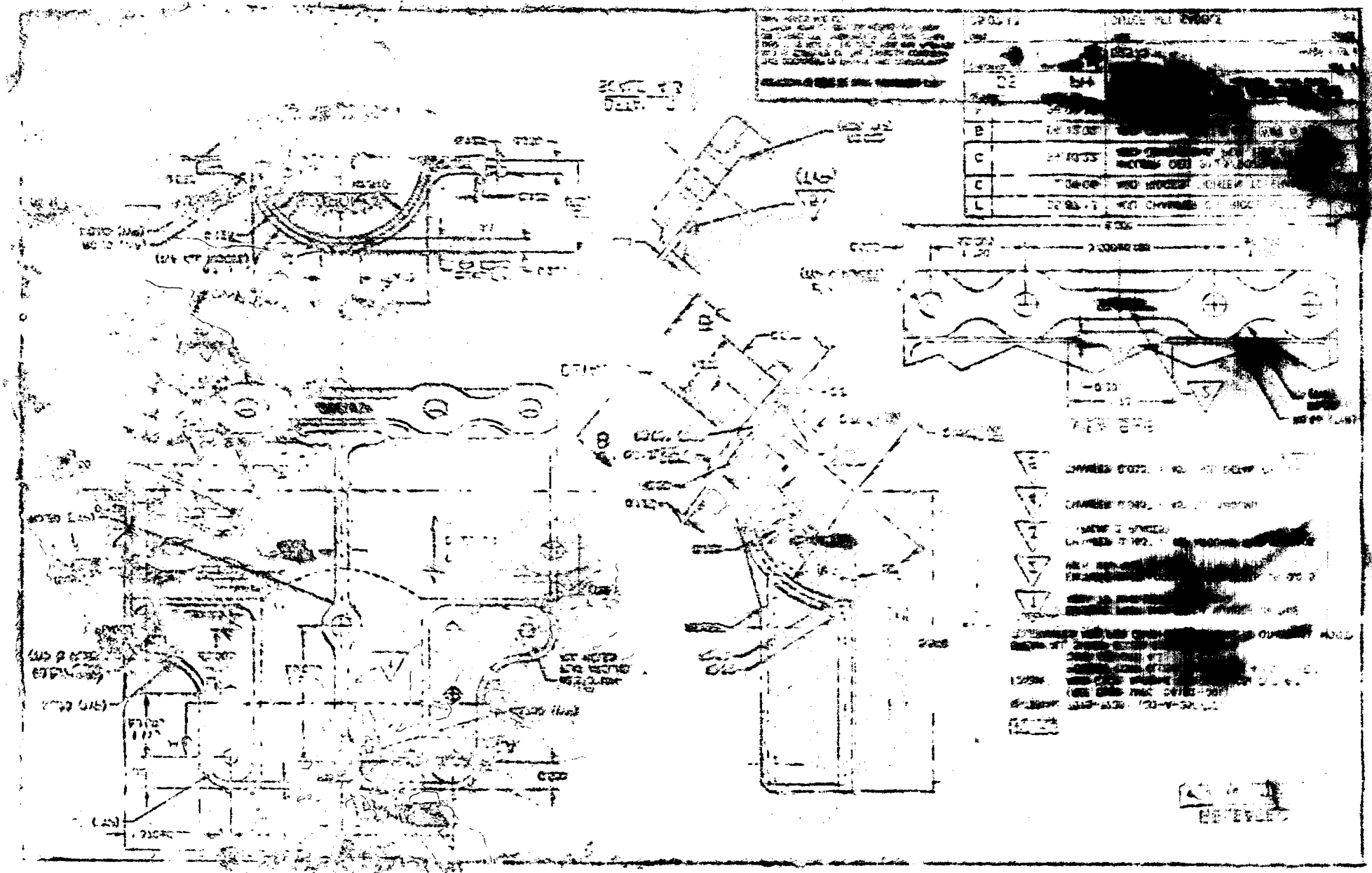


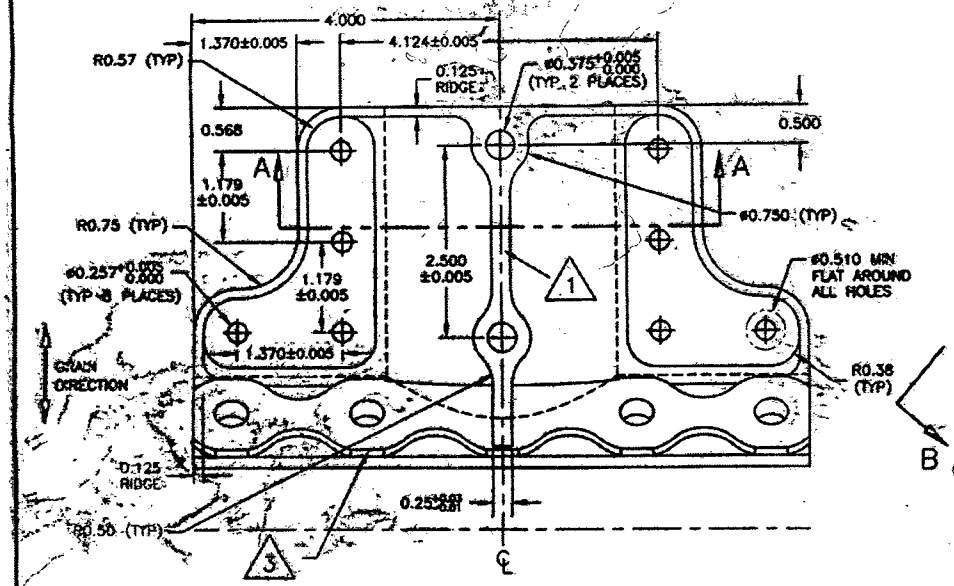
DETAIL C
SCALE 2:1

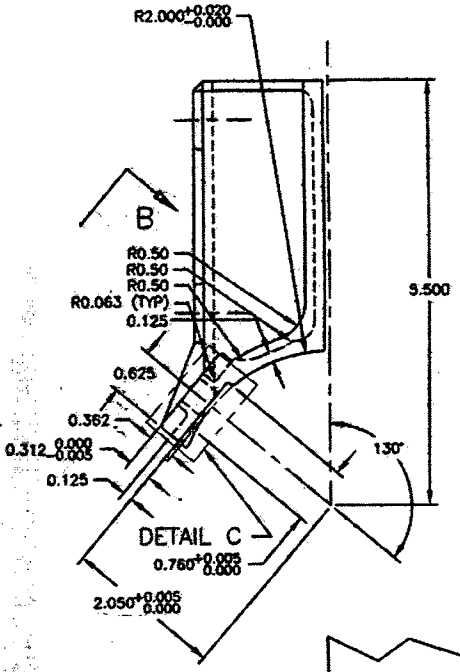


E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN: DS	DRAWN BY: PH	DART AEROSPACE LTD.	
CHECKED	APPROVED	DRAWING NO. D2572	REV. E SHEET 1 OF 1
DATE 05.07.13		TITLE INNER FWD SADDLE	SCALE 2:3





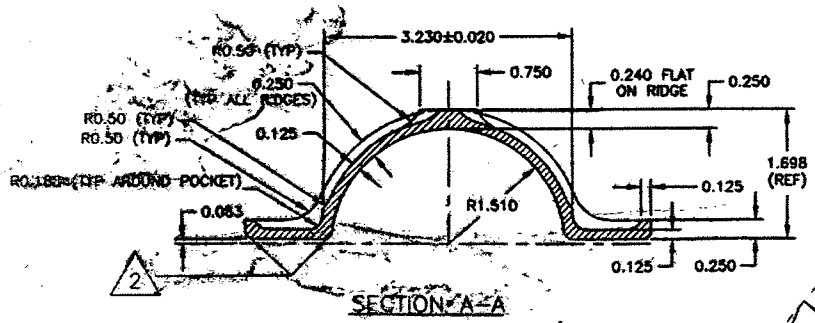


RELEASED
05.12.06

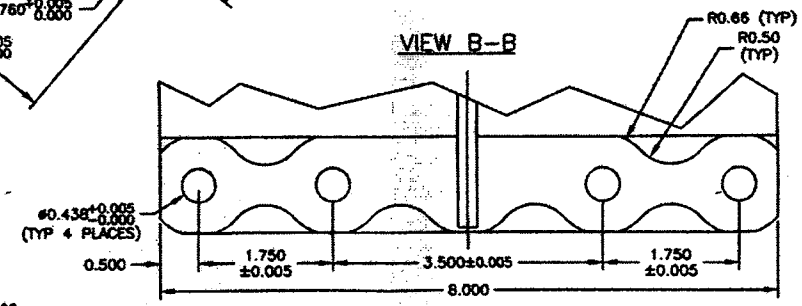
NOTES

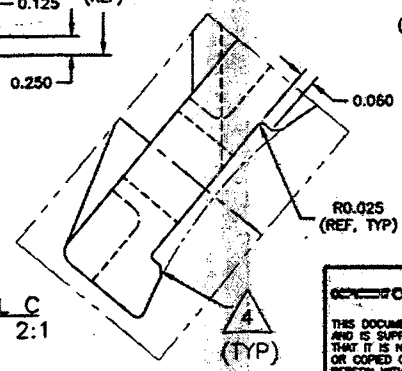
MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

1. ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
2. CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
3. CHAMFER 0.063 x 45° ALL AROUND
4. CHAMFER 0.033 x 45° (SEE DETAIL C) E



SECTION A-A





DETAIL C
SCALE 2:1

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN: DS	DRAWN BY: PH	DART	DART AEROSPACE LTD. MISSISSAUGA, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2574	REV. E SHEET 1 OF 1
DATE 05.07.13		TITLE INNER AFT SADDLE	SCALE 2:3

A

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.02.06	5.0	1x B24125 & 1x B24126 was left in the Acid over night, over etching the 2 saddles. Human error.	QS1042	Ensure employees stay on top & pay attention to work in progress. scrap & destroy the 2 ~~tubes~~ saddles	01/02/06	07.02.06	QS1042	07.02.06

NOTE: Date & initial all entries